

Work Order ID 54223

December 3, 2009 1:03:21 PM

Page 1

Item ID:

d3608-1F

Accept



Setup Start



Revision ID:

PB1 1041204

Item Name:

Lower Doubler

Stop



Start Date:

12/03/09

Start Qty:

1.00



Cust Item ID:

Customer:



Required Date:

12/04/09

Req'd Qty:

1.00



Reference:

Approvals:

Process Plan:

W

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Draw Nbr

Revision Nbr

D3608

~~PB1~~ 1041204

100



FLOW WATER JET

Waterjet

Memo

FLOW CNC Waterjet

I-Cut as per Dwg D3608
Deburr if necessary

Dwg Rev: RE Prog Rev: LM 2-

0.00

BB 9-12-4

110



QC2- Inspect parts off machine FAI/FAIB

QC

Quality Control

0.00

PB 9-12-4

120



QC8- Inspect parts - second check

QC

Quality Control

0.00

27801104



q

Work Order ID 54223

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Page 2

Item ID: d3608-1F

Revision ID: P1B 091203

Item Name: Lower Doubler

Start Date: 12/03/09 Start Qty: 1.00

Accept



Setup Start



Stop



Required Date: 12/04/09 Req'd Qty: 1.00



Cust Item ID:



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
Description

150



Packaging

Packaging

Identify as per dwg & Stock Location: StockSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberReject
NumberInsp.
Stamp

8/12/14

0.00

160



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/02/10 JK10/02/10

POSITIVE RECALL

ACTIVE 10/02/10 AUTH LASTED DATE 10.02.10

Picklist Print

December 3, 2009 1:03:20 PM

Page 1

Work Order ID: 54223



Parent Item: d3608-1F

Parent Item Name: Lower Doubler

Start Date: 12/03/09

Required Date: 12/04/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S20GA 		Purchased		No		100	sf	307.9136	0.7781 			BB 9-12-4

304/316 .040 Sheet

Warehouse

Location

Main Warehouse

MAT	307.9136158	
110076	1.37053684	
112567	38.0765789	
112885	83.1578	
113062	167.9323	
113077	17.3764	113062

DART AEROSPACE LTD	Work Order:	54223
Description: Low Fr Draft	Part Number:	D3608-1F
Inspection Dwg: D3608-1F Rev: PEF LIM PB1		Page 1 of 1

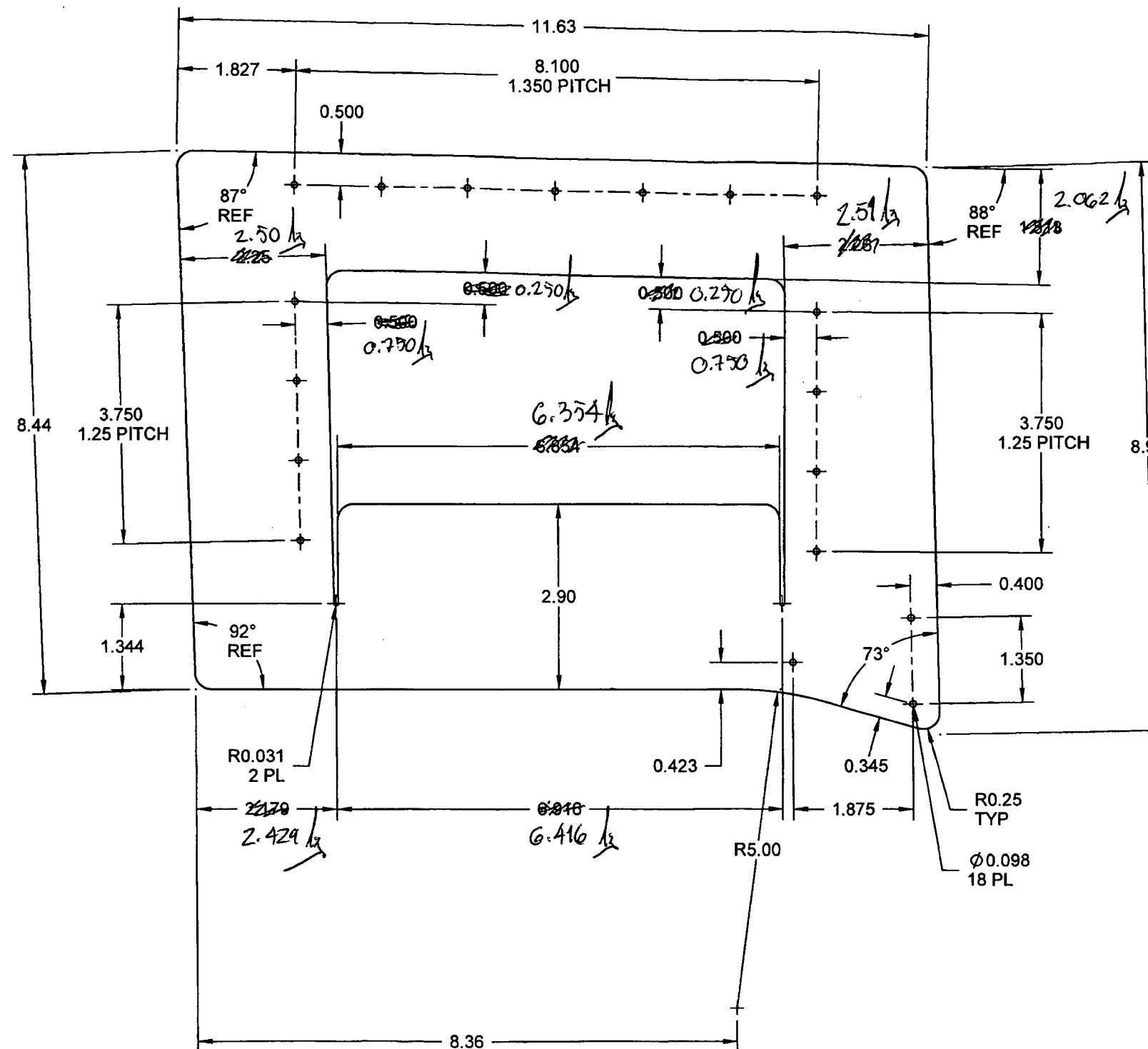
FIRST ARTICLE INSPECTION CHECKLIST

x First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
$\phi .098$	$+.004 - .001$.100	✓			
1.827	$+\frac{1}{12} .05$	1.818	✓	✗		
.500	$+\frac{1}{12} .010$.503	✗			
8.100	$+\frac{1}{12} .010$	8.099	✗			
1.350	$+\frac{1}{12} .010$	1.350	✓			
11.63	$+\frac{1}{12} .030$	11.622	✓			
.250	$+\frac{1}{12} .010$.250	✓			
2.511	$+\frac{1}{12} .030$	2.516	✗			
2.062	$+\frac{1}{12} .010$	2.067	✗			
3.750	$+\frac{1}{12} .010$	3.754	✗			
.750	$+\frac{1}{12} .010$.751	✓			
6.354	$+\frac{1}{12} .010$	6.357	✗			
1.25	$+\frac{1}{12} .030$	1.242	✗			
8.90	$+\frac{1}{12} .030$	8.892	✓			
.400	$+\frac{1}{12} .010$.399	✓			
1.350	$+\frac{1}{12} .010$	1.349	✗			
1.875	$+\frac{1}{12} .010$	1.876	✓			
6.416	$+\frac{1}{12} .010$	6.417	✗			
2.429	$+\frac{1}{12} .010$	2.433	✓			
8.44	$+\frac{1}{12} .030$	8.429	✗			
.040	$+\frac{1}{12} .010$.037	✓			

Measured by:	HR	Audited by:	S	Prototype Approval:	N/A
Date:	9-12-04	Date:	6/12/04	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D3608-1F LOWER DOUBLER

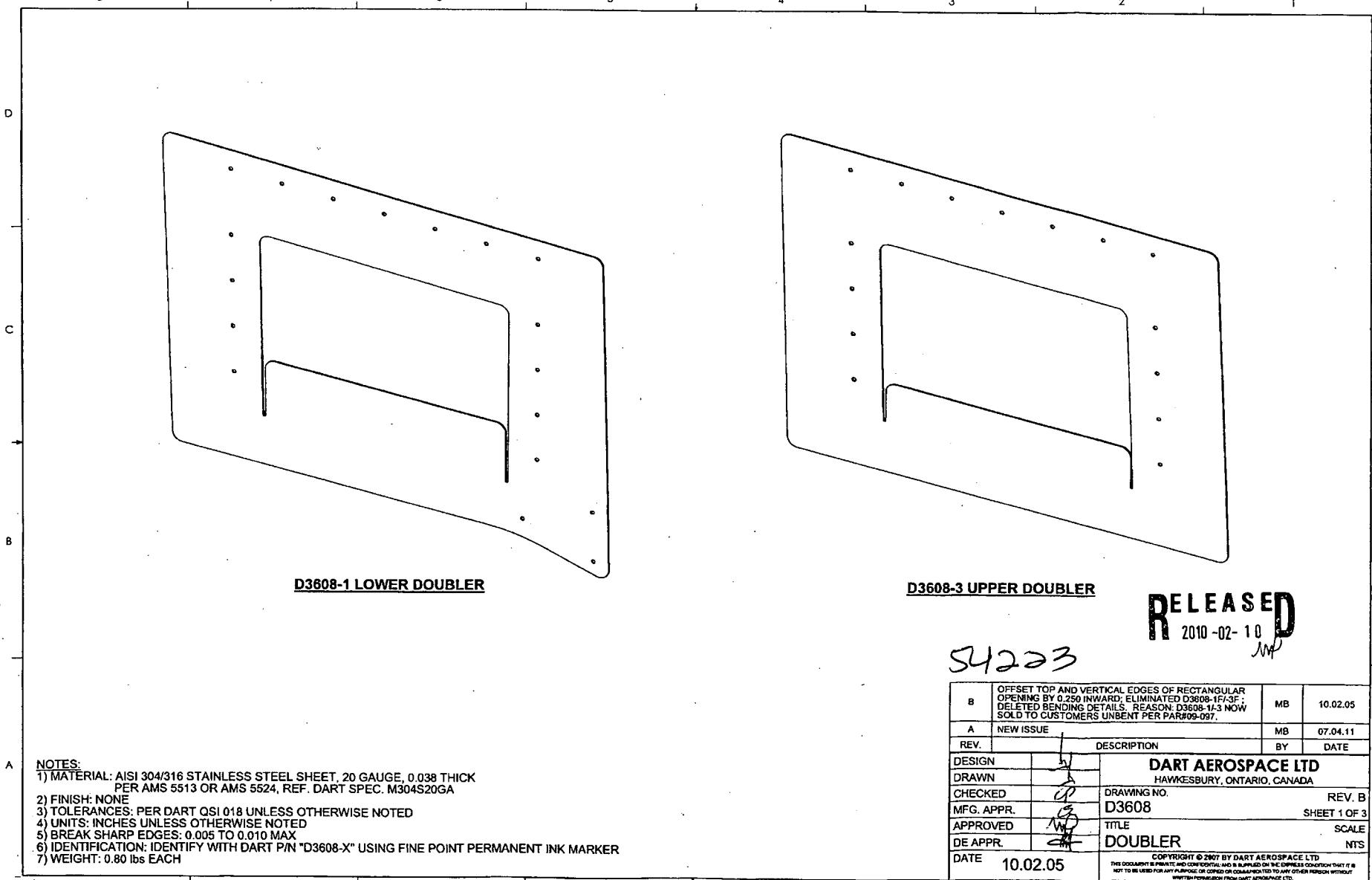
D3608-1F LOWER DOUBLER
MANUFACTURE PER D3608-1F rev. P1B. dxf
09.12.03

HAND CHANGES PER ~~1~~.
REQUIRES FEEDBACK FROM ~~1~~
CUSTOMER PRIOR TO RELEASING REV.B

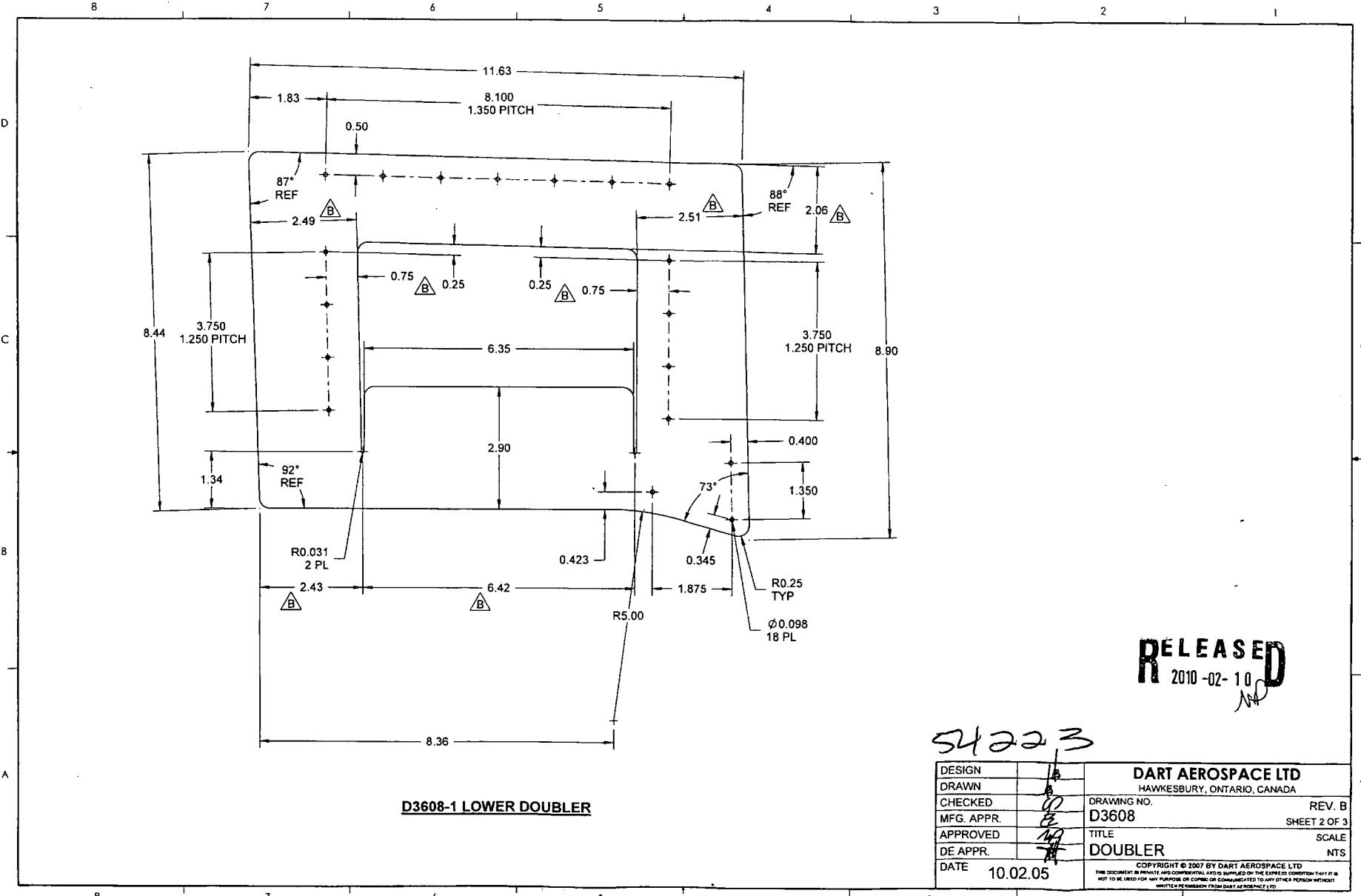
PRELIMINARY ISSUE

RELEASED
08/21/2014

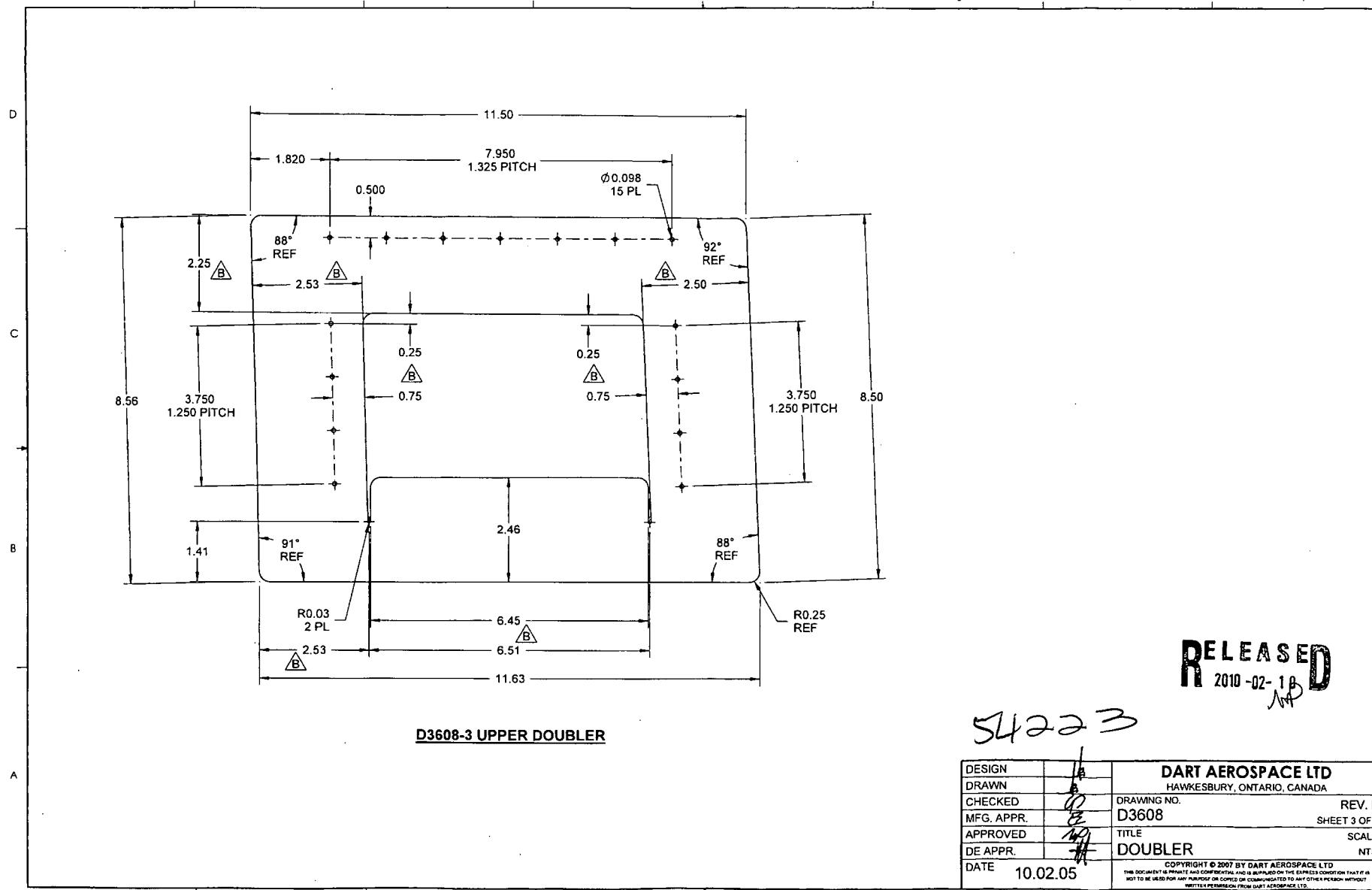
DESIGN	18	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	18		
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	DS	D3608	SHEET 3 OF 4
APPROVED	140	TITLE	SCALE
DE APPR.	-M	DOUBLER	NTS
DATE	07.04.11	COPYRIGHT © 2007 BY DART AEROSPACE LTD	
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B	OFFSET TOP AND VERTICAL EDGES OF RECTANGULAR OPENING BY 0.250 INWARD; ELIMINATED D3608-1F-3; DELETED BENDING DETAILS. REASON: D3608-1-3 NOW SOLD TO CUSTOMERS UNBENT PER PAR#09-097.	MB	10.02.05			
A	NEW ISSUE	MB	07.04.11			
REV.	DESCRIPTION	BY	DATE			
DESIGN	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA					
DRAWN	CP					
CHECKED	CP					
MFG. APPR.	C					
APPROVED	W					
DE APPR.	W					
DATE	10.02.05					
DRAWING NO. D3608 SHEET 1 OF 3						
TITLE DOUBLER NTS						
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8 7 6 5 4 3 2 1



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MFG. APPR.	14	REV. B
APPROVED	14	D3608
DE APPR.	14	SHEET 3 OF 3
DATE	10.02.05	SCALE NTS

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